

Work Order ID 62108

Thursday, September 16, 2010 8:55:42 AM



Page 1

Item ID: D2327-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer Bushing

Start Date: 9/16/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/23/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 ☐ Deburr

SA 10/10/01

20 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 10/10/01

20 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

G.A 10/10/01

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location WA

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/4 SP 200

10/10/04 JH
ME
10-10-04

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Picklist Print

Thursday, September 16, 2010 8:55:48 AM

Page 1

Work Order ID: 62108

Parent Item: D2327-3

Parent Item Name: Spacer Bushing





Start Date: 9/16/2010

Required Date: 9/23/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			100	f	52.3400	0.1563	3.290526			
304 ROUND BAR 0.375												10/10/01	

Location	Loc Qty	Loc Code
MAT	47	
111323	0	
114467	5.1	
114676	1.1	
115180	2.7	
115334	38.1	
MAT029	5.34	
113325	3.85	
114356	1.49	

3.287

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62108
Description: Spacer Bushing		Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.376	/			
Ø0.257	+0.005/-0.000	Ø.257	/			
1.750	+/-0.010	1.751	/			

Measured by:	<i>[Signature]</i>	Audited by:	A.A	Prototype Approval:	N/A
Date:	10/10/01	Date:	10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	<i>[Signature]</i>

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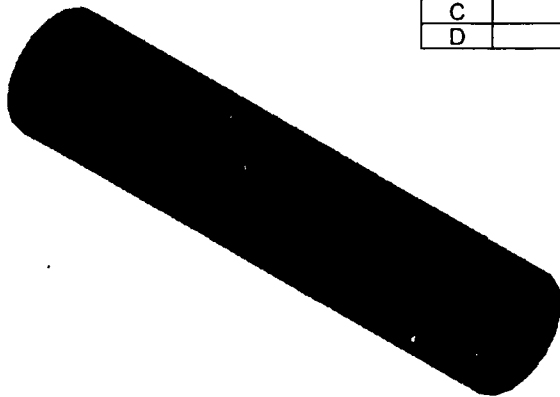
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

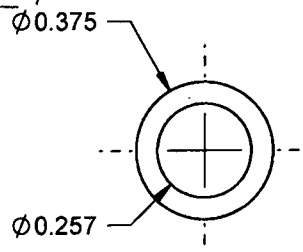
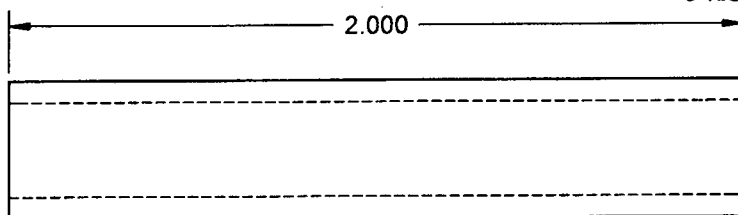


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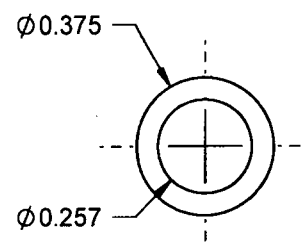
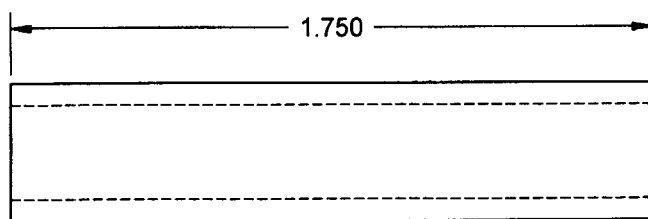
06.11.14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42108

DS10-9-16



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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